

**Work Order ID 116172**

Monday, April 07, 2014 11:36:13 AM

**\*116172\***

Page 1

Item ID: D4934-041

Revision ID:

Item Name: Blade Assembly

Start Date: 4/09/14 Start Qty: 8.00

Required Date: 4/18/14 Req'd Qty: 8.00

Reference:

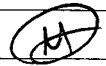
Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: 

Date: 14-04-07

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4934

PA4

REV. A W

110

Weld per dwg A/R Steel rod Batch: 1120854 0.00**\*110\***

Large Fab

Memo

0.00

Large Fab

 ML 14-05-05

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

8 FL 14-5-6

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

VERIFY TENSILE STRENGTH AFTER WELDING AS PER DWG NOTE 8

SPR  
14/5/6

8

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Required Date: 4/18/14 Req'd Qty: 8.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*140\***

Powdercoat

Memo

0.00

Powder Coating

\*\*\*MASK CARBIDE FACE PRIOR TO POWDERCOAT\*\*\*

START TIME: 11:05OVEN TEMPERATURE: 450FINISH TIME: 10:358 14-5-8 DAS 34 9-89

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

(8) 14-05-08 DAS 9 9-89

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

14/5/8 (8) DAS 32 9-89

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Page 3

Item ID: D4934-041

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Item Name: Blade Assembly

Start Date: 4/09/14 Start Qty: 8.00

Required Date: 4/18/14 Req'd Qty: 8.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
Description

170

QC21 - Final Inspection - Work Order Release

**\*170\***

QC

Quality Control

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

MLJ 14-05-09

MF  
14-5-8

\* **Picklist Print**

Monday, April 07, 2014 11:36:16 AM

Page 1

Work Order ID: 116172

**\*116172\***

Parent Item: D4934-041

**\*D4934-041\***

Parent Item Name: Blade Assembly

Start Date: 4/09/14

Required Date: 4/18/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.09.06 new issue DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2741		Manufactured	No				Each	13.0000		8			
-------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

**\*D2741\***  
Blade

\*\*

**(8)** ml 14.05.05

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

2

107206

2

Each

0.0000

8

\*\*

**(8)** ml 14.05.05

D4932-1-048

Manufactured No

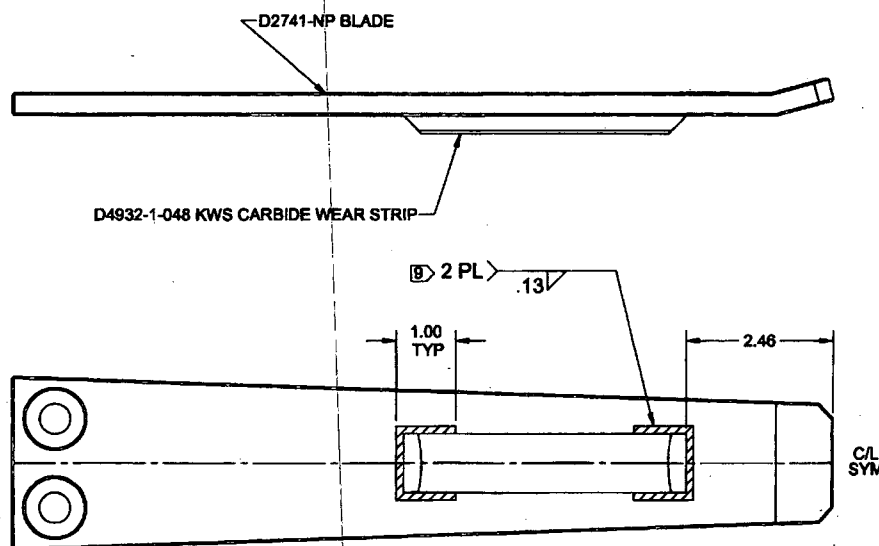
**\*D4932-1-048\***

KWS Carbide Wear Strip, 4.8" Long

B 117782 \* 8



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4934-041	BLADE ASSY
1	1	D2741-NP	BLADE
2	1	D4932-1-048	KWS CARBIDE WEAR STRIP



**D4934-041 BLADE ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 116172 NP

140402

RELEASE  
R 2014-04-03 U

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" PER DART QSI 005 4.3.5.2 (EXCEPT FOR CARBIDE FACE)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: WITH DART P/N "D4934-041" PER DART QSI 044 METHOD 8.1
- 7) WEIGHT: 4.12 LBS
- 8) VERIFY TENSILE STRENGTH (AFTER WELDING) BY HARDNESS TEST PER ASTM E18 TO 34-40 HRC
- 9) WELDING: PER QSI 004

A	NEW ISSUE	DB	13.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	AP		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.06.28		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4934** REV. A  
SHEET 1 OF 1  
TITLE **BLADE** SCALE NTS

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